

Date: Monday, 11/05/2009 1:22:52 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SHIM
Job Number : 47870	
Estimate Number : 13011	
P.O. Number :	Part Number : D36441
This Issue : 11/05/2009 S.O. No. :	Drawing Number : D3644 REVA
Prsht Rev. : NC	Project Number : N/A
First Issue : // Type : SMALL /MED FAB	Drawing Revision : A
Previous Run : 34549	Material :
Written By :	Due Date : 28/05/2009 Qty: 10 Um: Each
Checked & Approved By : <u>JUD 09.05.11</u>	
Comment : Est Rev:A New Issue 07-07-20 JLM	Verified By: EC

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S050	2024-T3 .050 sheet
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Comment: Qty.: 0.1747 sf(s)/Unit Total : 1.7472 sf(s)
 2024-T3 .050 sheet
 Batch: 111381 18 9-5-07

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D3644
 Dwg Rev: A
 Prog Rev: A

18 9-5-07

(24)

2-Deburr if necessary 18 9-5-07

8/09/05/27 (24)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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18 9-5-07

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

8/07/05/27 (24) center

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1
 Chemical Conversion Coat as per QSI 005 4.1

1 MD 09/05/27 (24)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 11/05/2009 1:22:52 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHIM

Job Number: 47870

Part Number: D36441

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(24)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 09/05/27

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock
Location: ST. 243

SS 09/05/27 (x24)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



09/05/27

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 09-05-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	47870
Description: Shim		Part Number:	D3644-1
Inspection Dwg: D3644 Rev: A		Page 1 of 1	

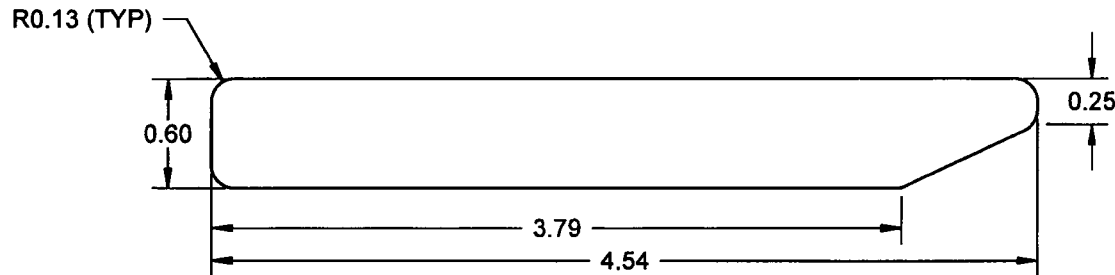
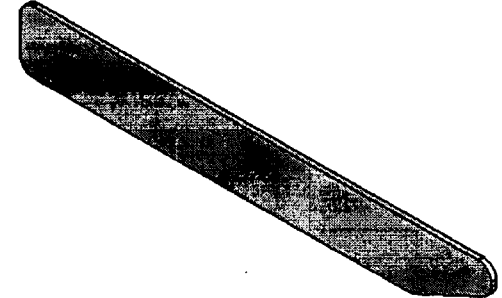
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.60	+/-0.030	.602	X			
3.79	+/-0.030	3.790	X			
4.54	+/-0.030	4.542	X			
0.25	+/-0.030	.248	X			
R0.13	+/-0.030	.13	X			
0.050	+/-0.010	.050	X			

Measured by:	B	Audited by:	S	Prototype Approval:	N/A
Date:	9-5-27	Date:	09/05/27	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.10.25	New Issue	KJ/EC/DD	[Signature]



D3644-1 SHIM
(REPLACES GENEVA P/N G10610-3)

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 147870

RELEASED
 07.09.07

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.050 THICK PER QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.050)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3644-1" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.01lbs

A	NEW ISSUE; REPLACES G10610-3	LE	07.07.27
REV.	DESCRIPTION	BY	DATE
DESIGN	DTI	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	CE		
CHECKED	EB	DRAWING NO.	REV. A
MFG. APPR.	EB	D3644	SHEET 1 OF 1
APPROVED	NO	TITLE	SCALE
DE APPR.	SH	SHIM	1:1
DATE	07.07.27	COPYRIGHT © 2007 BY DART AEROSPACE USA, INC. <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	